

Date: Thursday, 8/23/2007 11:52:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL ASSEMBLY
Job Number : 34237	
Estimate Number : 10504	
P.O. Number :	Part Number : D3204041
This Issue : 8/23/2007 S.O. No. :	Drawing Number : D3204 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 32822	Material :
Written By :	Due Date : 9/3/2007 Qty: 4 Um: Each
Checked & Approved By : <u>07.08.23</u>	
Comment : ESTD 05.08.11 Added Step 25 KJ/JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32041 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

Pick:

Qty	Part Number	Description	Batch
1	D3204-1	Tube	B25031 → 2x B35873 → 1

2.0 D32043 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-3	Arm	B32840 → 3

3.0 D32045 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-5	Arm	B32841 → 3

4.0 D32049 Pedal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pedal

Pick:

Qty	Part Number	Description	Batch
1	D3204-9	Pedal	B32842 → 3

08/01/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:38 AM
User: Kim Johnston

Process Sheet

414 704

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 34237

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D320411

Plate



(PK) →

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Plate

Pick:

Qty Part Number Description
1 D3204-11 Plate

Batch

B 32839 →

3

dy 08/01/30

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. ✓

2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. ✓

3- Use JB weld compound to plug the hole after assembly. ✓

4- Grind JB weld flush after it is cured. ✓

Identify as D3204-041

dy 08/01/30

(3x)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

dy 08-02-01 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

dy 08/02/01 (3)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/02/05 (3)

10.0

POWDER COATING

POWDER COATING



M106442



(3X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

M-L 08/02/05

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-02-05

(X2)

D3204-13 B 35970 → 6x dy

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/02/01	5.1	ADD D3204-13 B# 35970 ADD Step to Run parts from stock	[Signature]	08/02/01	#6	[Signature]	[Signature]

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/01	5.1							

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 34237

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
2	D3204-7	Bushing	B 35632

Batch

B 35632

JS 08/02/06 (3)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

JS 08/02/06 (3)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/02/06 (3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

JS 08/02/06 (3)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

JS 08/02/06 (3)

Job Completion



JS 2008/2/14

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

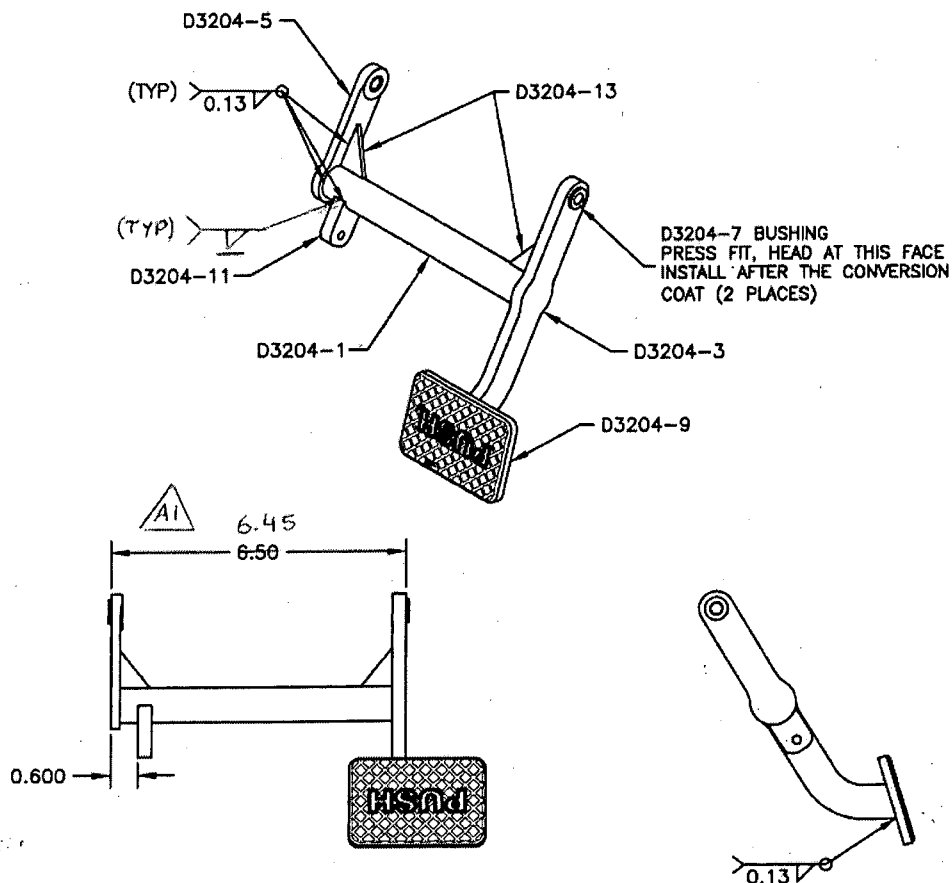
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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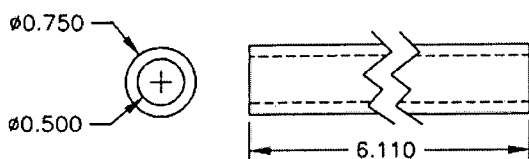
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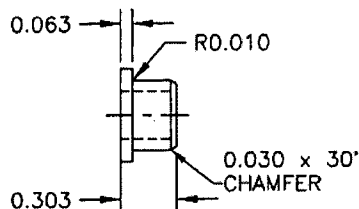


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

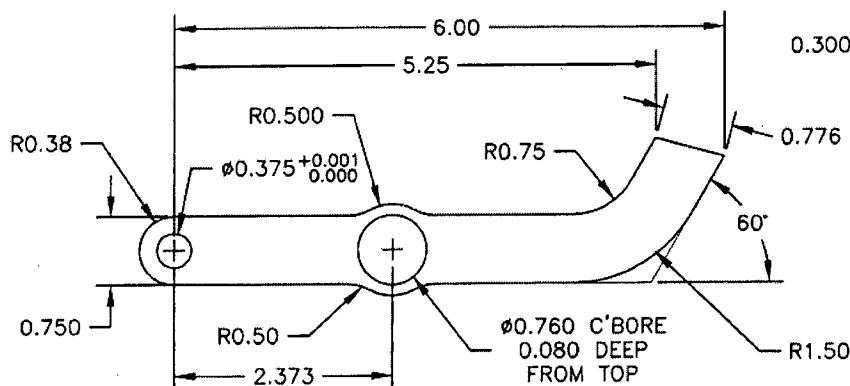
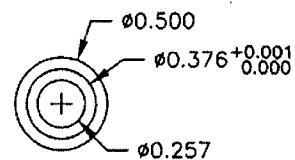
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04.04.05



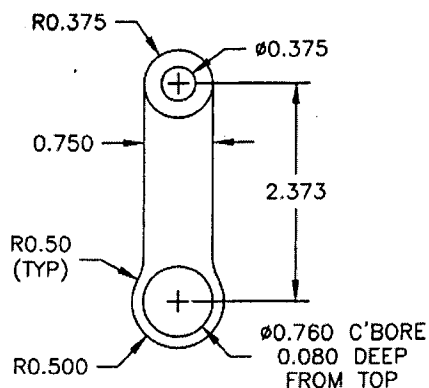
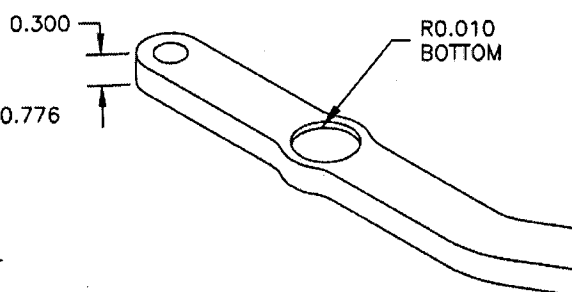
2 D3204-1 TUBE
SCALE 1:2



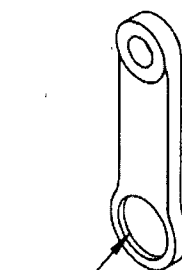
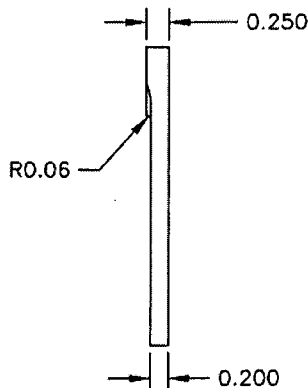
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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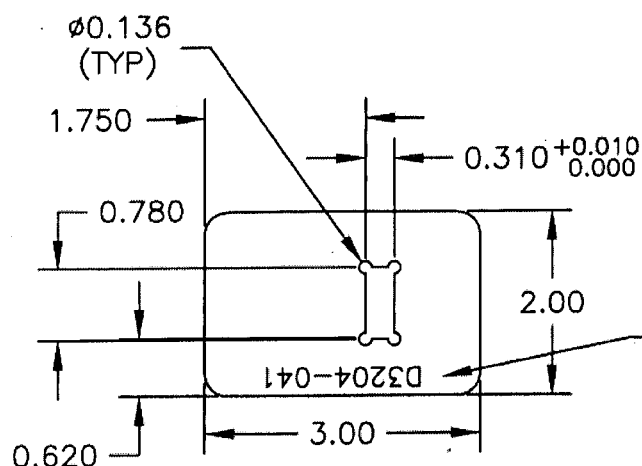
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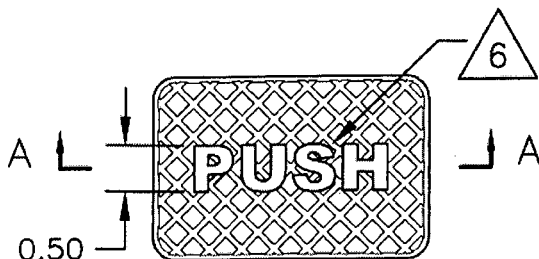


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CHECKED <i>RT</i>	APPROVED <i>RT</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

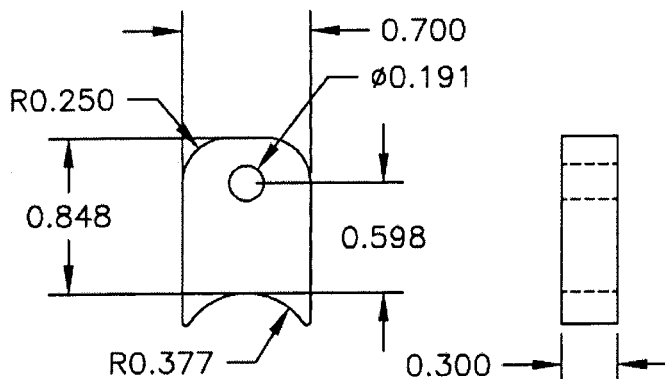
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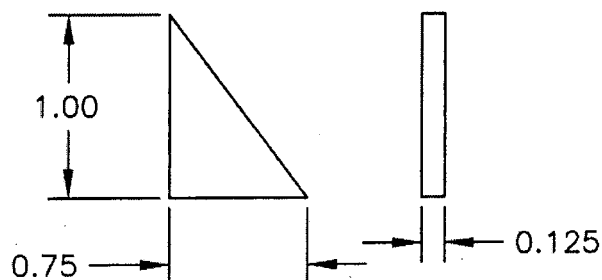
VIEW A-A
SCALE 1:2



D3204-9 PEDAL
SCALE 1:2



D3204-11 PLATE
SCALE 1:1



D3204-13 GUSSET
SCALE 1:1

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D3206-1 - Item
04-133 - Bolt
A16050466 - washer